

Work Order ID 85766

85766

Page 1

Thursday, June 14, 2012 3:16:47 PM

Item ID: D3524-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lower Plate

Start Date: 6/14/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 6/15/2012 Req'd Qty: 4.00 ***4*** Customer:

Reference: *June 12-06-14*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3524 | Rev A |

| | | | | | | | | | |
|----------------|------------------------|------|--|--|--|--|--|--|--|
| 100 | | 0.00 | | | | | | | |
| *100* | BAND SAW | | | | | | | | |
| Bandsaw | Memo | 0.00 | | | | | | | |
| Jeaspa Bandsaw | Cut Blanks 2.750" Long | | | | | | | | |

RT 12-06-14 (x4)

| | | | | | | | | | |
|------------------------------|--|------|--|--|--|--|--|--|--|
| 110 | | 0.00 | | | | | | | |
| *110* | HAAS CNC VERTICAL MACHINING #1 | | | | | | | | |
| HAAS 1 | Memo | 0.00 | | | | | | | |
| HAAS CNC vertical machine #1 | 1- Mill as per Folio FA699 Rev: <i>KA</i> & Dwg D3524 Rev: <i>A</i> 2-Deburr per dwg D3443 | | | | | | | | |

RT 12-06-14 (x4)

| | | | | | | | | | |
|-----------------|---|------|--|--|--|--|--|--|--|
| 120 | | 0.00 | | | | | | | |
| *120* | QC2- Inspect parts off machine FAI/FAIB | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

RT 12-06-14 (x4)

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Thursday, June 14, 2012 3:16:47 PM

Item ID: D3524-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lower Plate

Start Date: 6/14/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/15/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

130 QC8- Inspect parts - second check

0.00

SL 12-06-15

130

QC

Memo

0.00

Quality Control

140 Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

150 Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

150

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

3200F

2:15

M121279

(W)

4

12-6-15

4X

✓

M-F
12/06/18

Work Order ID 85766***85766***

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Thursday, June 14, 2012 3:16:47 PM

Item ID: D3524-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lower Plate

Start Date: 6/14/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/15/2012 Req'd Qty: 4.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

4 0 12-6-18.

170

Identify as per dwg & Stock Location: 53 0.00***170***

Packaging

Memo

0.00

Packaging

4 80 12-6-19.

180

QC21- Final Inspection - Work Order Release 0.00

180

QC

Memo

0.00

Quality Control

12/6/19

MF
12-06-19

Picklist Print

Thursday, June 14, 2012 3:16:46 PM

Page 1

Work Order ID: 85766

Parent Item: D3524-1

Start Date: 6/14/2012

Required Date: 6/15/2012

Parent Item Name: Lower Plate

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-04-18 EC
IPP Rev:B Now CNC Machined 07-09-24 JLM verified by DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6B0.375X03.000 | | Purchased | No | | | 110 | f | 12.4000 | 0.2252 | 0.9482105 | | | |
| 6061T6 BAR .375 X 3.00 | | | | | | | | | | | | | |

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| MAT001 | 12.4 | |
| 105225 | 2.82 | |
| 18237 | 9.58 | |

21 12-06-14
1.3

| | | | |
|--|--|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 84303 |
| Description: upper plate assy | | Part Number: | 03524-1 |
| Inspection Dwg: 03524 Rev: A | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------------|------------------|--------|--------|----------------------|----------|
| .47 | +/- .030 | .470 | ✓ | | | |
| 2.00 | +/- .030 | 2.002 | ✓ | | | |
| 1.063 | +/- .010 | 1.063 | ✓ | | | |
| 1.250 | +/- .010 | 1.250 | ✓ | | | |
| 1.000 | +/- .010 | 1.000 | ✓ | | | |
| Ø .144 | + .005/- .001 | .146 | ✓ | | | |
| .250 | +/- .010 | .244 | ✓ | | | |
| 1.625 | +/- .010 | 1.625 | ✓ | | | |
| .44 | +/- .030 | .440 | ✓ | | | |
| | | | | | | |
| .250 | +/- .010 | .243 | ✓ | | | |
| 2.50 | +/- .030 | 2.502 | ✓ | | | |
| Ø .750 | + .005/- .000 | .751 | ✓ | | | |
| | | | | | | |
| .200 x .45 | +/- .030 | .185 | ✓ | | | |
| .375 | +/- .005/- .000 | .375 | ✓ | | | |
| .711 | +/- .010 | .706 | ✓ | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

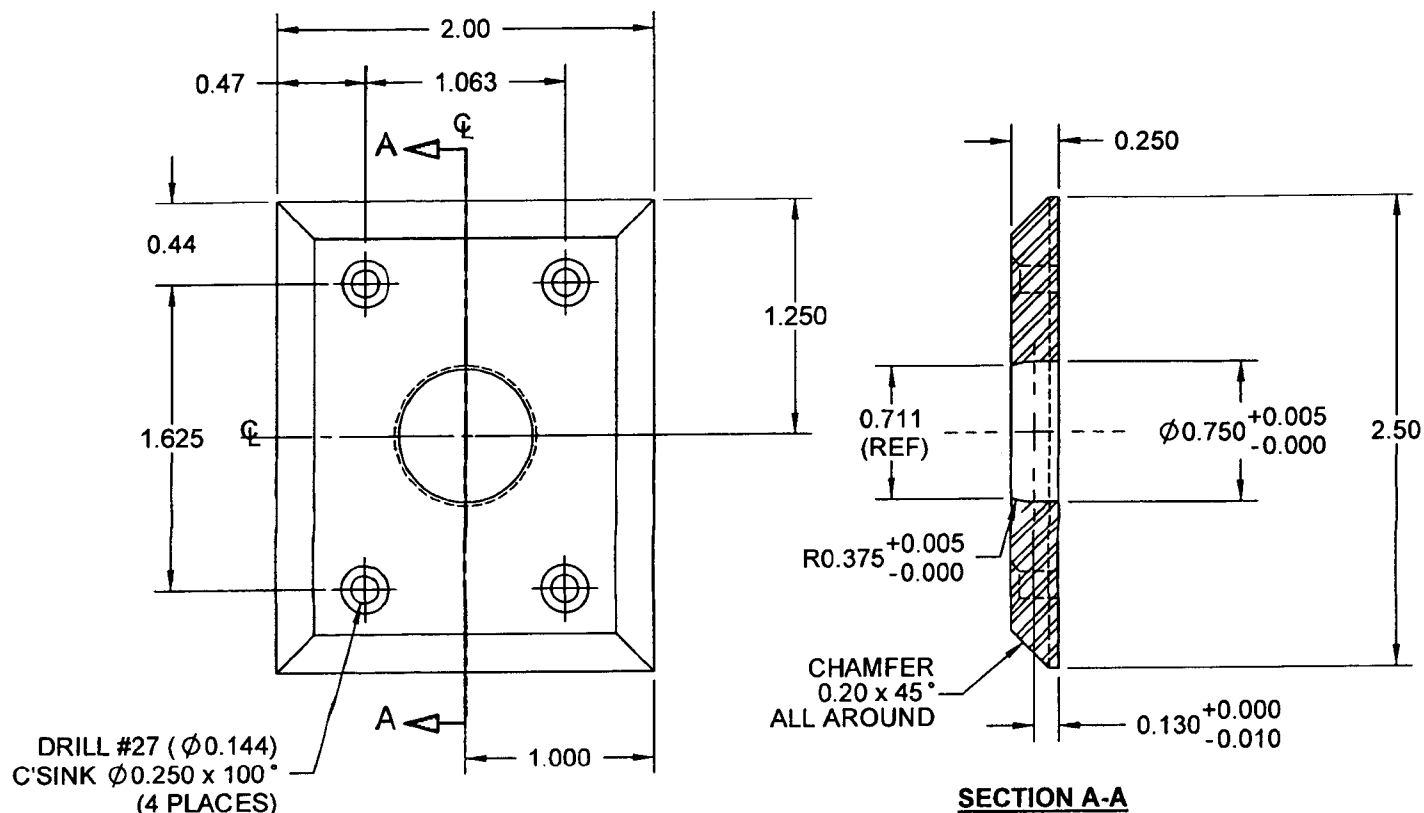
| | | |
|------------------------|-----------------------|------------------------------|
| Measured by: RT | Audited by: SL | Preliminary Approval: |
| Date: 12-06-14 | Date: 12-06-15 | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------|------------|----------|
| E | 10.04.14 | Added preliminary approval | KJ | |

10.06.15



| | | | |
|------------------|--------------------------------|---|------------------------|
| DESIGN CB | DRAWN BY CB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
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| DATE 07.07.24 | TITLE UPPER AND LOWER PLATE | | SCALE 1:1 |
| REV A | DATE 07.07.24 | DESCRIPTION NEW ISSUE | |

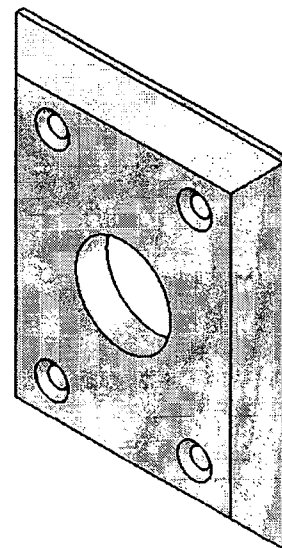


D3524-1 LOWER PLATE

RELEASED
07.08.03 [Signature]

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T651/T6510/T6511/T62 BAR PER QQ-A-225/8 OR AMS 4115/4116/4117/4128 OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART SYMMETRIC ABOUT ϕ

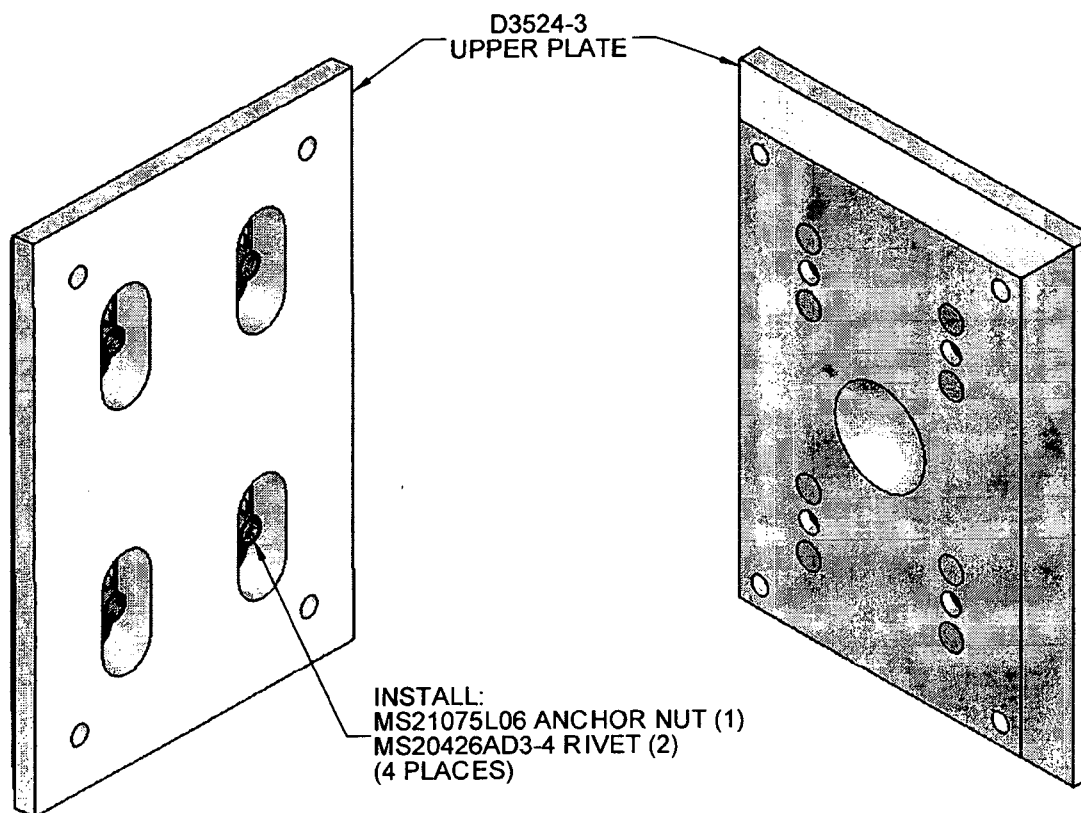


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| DATE 07.07.24 | | TITLE UPPER AND LOWER PLATE | SCALE 1:1 |



D3524-041 UPPER PLATE ASSEMBLY

RELEASED
07.08.03 **[Signature]**

PARTS LIST:

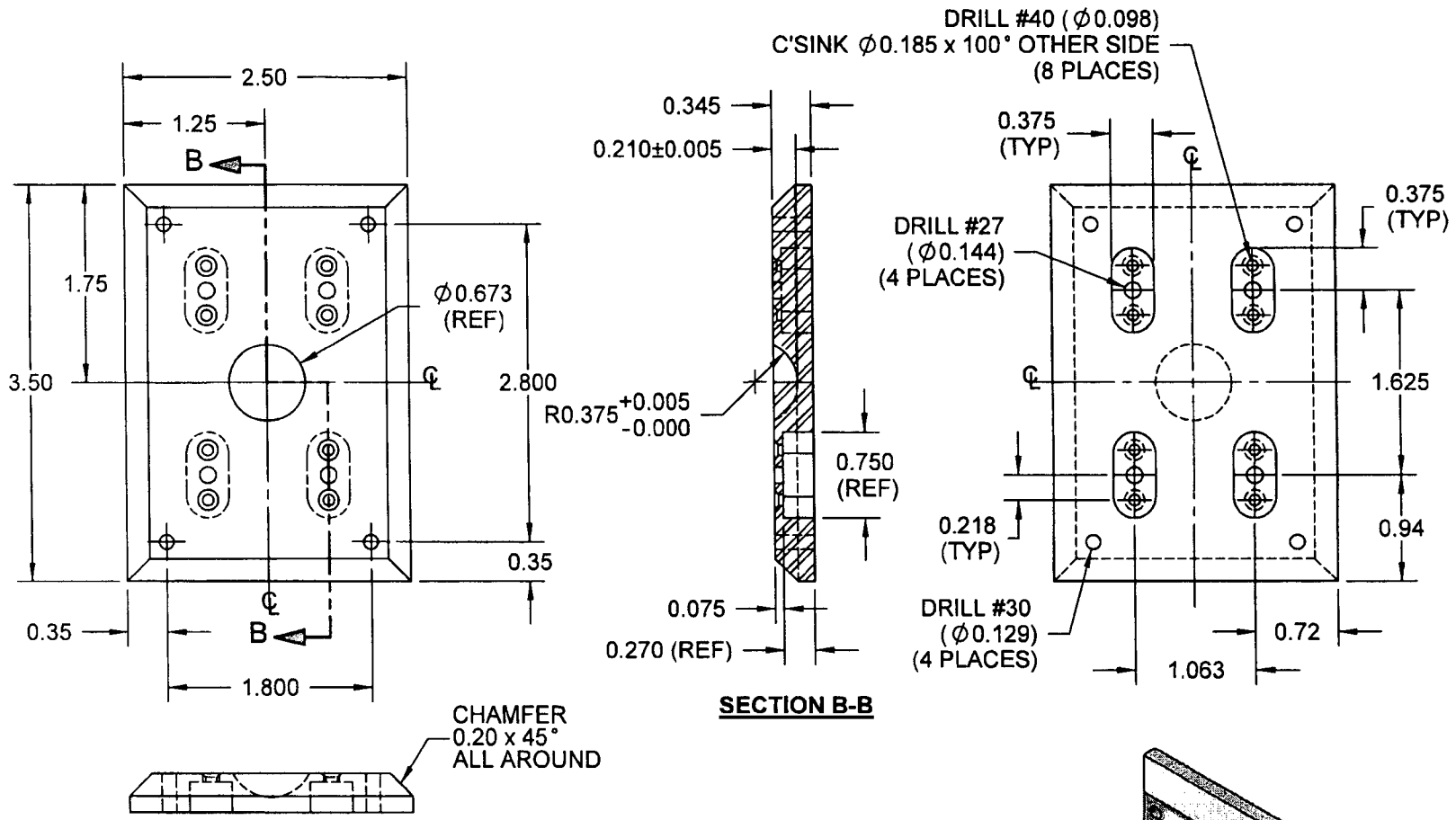
| QTY | PIN | DESCRIPTION |
|-----|--------------|----------------------|
| X | D3524-041 | UPPER PLATE ASSEMBLY |
| 1 | D3524-3 | UPPER PLATE |
| 4 | MS21075L06 | ANCHOR NUT |
| 8 | MS20426AD3-4 | RIVET |

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| DATE | 07.07.24 | TITLE | D3524 | REV. A |
| | | UPPER AND LOWER PLATE | | SHEET 3 OF 3 |
| | | | | SCALE 2:3 |



D3524-3 UPPER PLATE

- NOTES:
- 1) MATERIAL: ALUMINUM 6061-T6/T651/T6510/T6511/T62 BAR PER QQ-A-225/8 OR AMS 4115/4116/4117/4128 OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
 - 6) PART SYMMETRIC ABOUT ϕ

RELEASED
07.08.03